

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023388**Date Inspected:** 05-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

BAY 14

Orthotropic Box Girder (OBG)

This QA Inspector observed ZPMC welding personnel performing Shielding Metal Arc Welding (SMAW) of fillet weld on unequal angles for Segment 7BW. The weld joint no. SSD022-PP51.5 from 085 to 122 is in progress. The welder is identified as 207540. Welder was welding in 3F (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2113.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Longitudinal Diaphragm for Segment 7AW. The weld joint no. SEG-033B-024 and 008 is in progress. The welder is identified as 045260. Welder was welding in 3G (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-TC-U4b-F.

This QA Inspector observed ZPMC welding personnel performing Shielding Metal Arc Welding (SMAW) of fillet weld on unequal angles for Segment 6CW. The weld joint no. SSD030-PP44.5 from 005 and 006 is in progress.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The welder is identified as 066422. Welder was welding in 3F(Vertical) and 4F(Overhead) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2112 and WPS-B-P-2113.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Longitudinal Diaphragm for Segment 6AW. The weld joint no. SEG-027D-034 and 008 is in progress. The welder is identified as 045260. Welder was welding in 3G (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-TC-U4b-F.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Longitudinal Diaphragm for Segment 6AW. The weld joint no. SEG-027D-034 and 008 is in progress. The welder is identified as 045260. Welder was welding in 3G (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-TC-U4b-F.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Longitudinal Diaphragm for Segment 6AW. The weld joint no. SEG-027F-005 is in progress. The welder is identified as 045196. Welder was welding in 3G (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-TC-U4b-F.

This QA Inspector observed ZPMC welding personnel performing Shielding Metal Arc Welding (SMAW) of fillet weld on unequal angles for Segment 6AW. The weld joint no. SSD031-PP39.5 from 085 and 122 is in progress. The welder is identified as 047856. Welder was welding in 3F (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2113.

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Longitudinal Diaphragm for Segment 6AW. The weld joint no. SEG-027D-004 is in progress. The welder is identified as 058242. Welder was welding in 4G (Vertical) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-TC-U4b.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Plate between SP 542A to SP 582A for Segment 9AE. The weld joint no. SEG-050A-002 is in progress. The welder is identified as 207288. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2221-B-L2c-S.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Plate between SP 105A to SP 132A for Segment 9AW. The weld joint no. SEG-049A-002 is in progress. The welder is identified as 204730. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2221-B-L2c-S.

The designated ZPMC CWI for the West Line is Mr. Shen Fu Yoo and QC Mr. Li Ming Yang and Mr. Liu Rudan.

BAY 19

Bike Path

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector randomly observed ZPMC welding personnel performing grinding for Bike Path BK-4A-005.

The designated ZPMC CWI for Mr. Liu Hua Wen and QC Mr. Sheng Jian Guo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
